Date:

Friday, 21/07/2006 12:01:42 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name

: LUG

Job Number

Estimate Number

: 11065

P.O. Number

: NIA : 21/07/2006

S.O. No. : NA

Part Number

This Issue Prsht Rev.

: NC : NA

: 27971

Drawing Number

: D2944

Project Number

: D2944 REV A

Drawing Revision

KJ/RF

: N/A

Material **Due Date** AIM:

: 07/08/2006

20 Um:

Each

Previous Run Written By

Comment

First Issue

Checked & Approved By

: Est B 04.01.21

Type

Reformat; Added Step 6

: MACHINED PARTS

Est. C 06.07.21 waterjet Qty:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M6061T6B0187X04000

6061-T6 Bar .178" x 4.0"



Comment: Qty.:

0.2581 f(s)/Unit Total: 5.1618 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11) 0.188" thick

Identify for D2944

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2944

Dwg Rev: A

Prog Rev:__A



2-Deburr if necessary

SAD

ZΟ

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

4.0

Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOUR

5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: NAC

Date:

Friday, 21/07/2006 12:01:42 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Part Number: D2944

Job Number: 27971

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



De 06/08/10

Date: User: Tuesday, 7/18/2006 3:00:56 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 27971 Job Number **Estimate Number**

: 11065

P.O. Number

This Issue

Prsht Rev.

First Issue

: 7/18/2006

: NC

Previous Run

: //

Type

S.O. No. :

: MACHINED PARTS

Part Number

: LUG

Drawing Name

: D2944 : D2944 REV A

Drawing Number Project Number

: N/A

Drawing Revision

Due Date

Material

: A

: 8/7/2006

Qty:

20 Um:

Each

Written By Checked & Approved By

Comment

: Est B 04.04/21

Reformat; Added Step 6

KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0187X04000

6061-T6 Bar .178" x 4.0"

Comment: Qty.:

0.2581 f(s)/Unit

Total: 5.1618 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11) 0.188" thick

Identify for D2944

Batch:

2.0

BAND SAW

BAND SAW

Comment: BAND SAW

1) Blank makes (2) D2944 Cut blank: 4.00" x 5.900" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA024 and Dwg D2944

Identify as D2944

Tumble and Deburr any rough edges after tumbling.

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:			WOI	RK ORDER CHANGES	}			
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date Qty	Approval Mfg / Design Mgr	Approval QC Inspector
NCR:		•	WORK ORDE	R NON-CONFORMAN	CE (NCR)		
DATE	OTED	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
								
Part No	:	PAR #:	Fault Category	NCR: `	 Yes No	DQA:	Date.	1
	ate & initial a				QA: N/C CI		Dute:	

H:\forms\Quality Assurance\approved forms\NCRWO revC

Pate:

Tuesday, 7/18/2006 3:00:56 PM

User:

Kim Johnston

.....

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

1

Job Number: 27971

Part Number: D2944

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

DC



7.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
						·			
NCR:		1	WORK ORDE	R NON-CONFORMA	•)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval Design Mgr	Approval QC inspector
DATE		Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section			
				-					
Part No):	PAR #:	Fault Category	:NCR:	Yes No	DQA:		Date:	
NOTE: D	NOTE: Date & initial all entries				QA: N/C Cld	sed:		Date:	

H:\forms\Quality Assurance\approved forms\NCRWO revC

\$

DART AEROSPACE LTD

Description: Step Mounting Plate

Part Number: D2944

Inspection Dwg: D2944 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.559	+/-0.010	0.560	V		Vern	
2.715	+/-0.005	2.714			Vern	
Ø0.257	+0.005/-0.000	00-259			Vern	
3.40	+/-0.030	3.395			Vern	
	·					
	٠					
	:					
. ,						
	:					
						•
APP.						

Measured by:	SAD	Audited by:	Prototype Approval:	N/A
Date:	80:80:90	Date: 06.08.09	Date:	NA

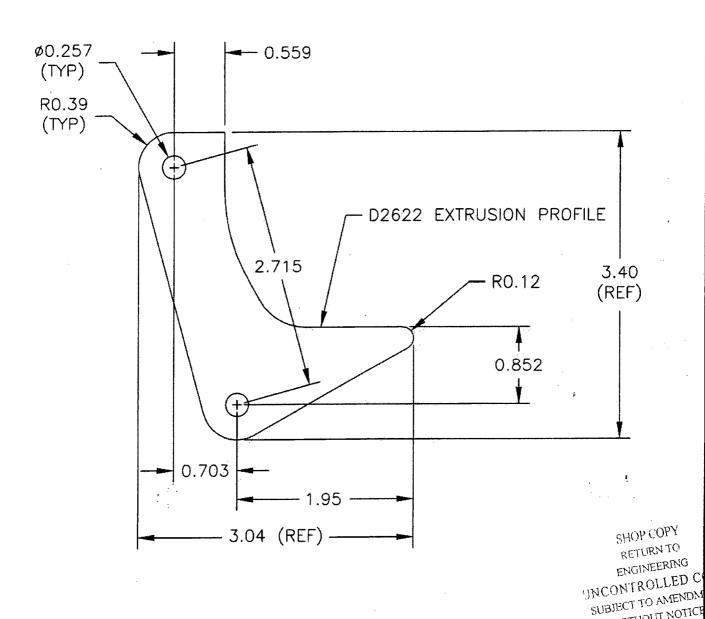
Rev	Date	Change	Revised₁by	Approved
Α	03.11.27	New Issue	KJ/RF	14
·				



	and the second s		
DESIGN	2 DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. A
H	-	D2944	SHEET 1 OF 1
DATE		TITLE	SCALE
99.12.13		STEP MOUNTING PLATE	1;1
Α	99.12.13	NEW ISSUE	

WITHOUT NOTIC

RELEASED 19942-21 ps



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

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